JLM

Monday, 2/11/2008 11:38:26 AM Date JIser: Kim Johnston Customer : CU-DAR001 Dart Helicopters Services Job Number : 37314 Estimate Number : 12867

: 2/11/2008

: NC

: //

: 32758

S.O. No. :

Type

Machine Or Operation:

Comment: DOCUMENT CONTROL

: SMALL /MED FAB

97.05.10 new issue EC

Est Rev:B 07-07-06 As per Rev E

P.O. Number

This Issue

Prsht Rev.

First Issue

Written By

Comment

Job Number:

Seq. #:

1.0

2.0

Previous Run

Checked & Approved By

Additional Product

Process Sheet

: DART 4-MAN 3-POINT AFT FACING SHOULDER **Drawing Name** HARNESS ASSEMBLY Part Number : D412702045B · IIN D412-702 REV E Drawing Number · N/A Project Number : E **Drawing Revision** Material : 2/18/2008 Each Due Date Qty: 1 Um: Description: DOCUMENT CONTROL KS 08-03-1 Photocopy bluefile & type labels per PPP D412-702-045B CHG002 HARNESS ASSEMBLY 2.0000 Each(s)

Comment: Qty.: 2.0000 Each(s)/Unit

D412702113B

Comment: Qty.:

Total: 2.0000 Each(s)

Bolt

D3572041 Comment: Qty.:

HARNESS ASSEMBLY

HARNESS ASSEMBLY

2.0000 Each(s)/Unit

2.0000 Each(s)/Unit Total: 2.0000 Each(s) **GUIDE ASSEMBLY**

Total:

B31870

5.0 AN416A Comment: Qty.: 2.0000 Each(s)/Unit

Bolt

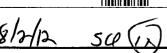
AN425A

BOLT

2.0000 Each(s) Total: 8949

Comment: Qty.: 4.0000 Each(s)/Unit

4.0000 Each(s) Total:



6.0

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Duitino	Tospace							
W/O:		WORK ORDER CH	HANGES					
DATE	STEP	PROCEDURE CHANGE	I	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No);	PAR #: Fault Category:	NCR:	Yes	No DQ	A: <u></u>	<u>`</u> Date: <u>⟨</u>	100/5
			(QA:	N/C Close	d:	<u>)</u> Date: <u>⟨</u> _ Date: _	
-								

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B			Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspector				
							1					

NOTE: Date & initial all entries

Date: User:	Monday, 2/11/2008 Kim Johnston		ess Sheet	·
y Cușto	mer: CU-DAR001	Dart Helicopters Services	Drawing Name: DART 4-MAN 3-F ASSEMBLY	POINT AFT FACING SHOULDER HARNESS
≇ Job Num	ber: 37314		Part Number: D412702045B	
Job Number:				
Seq. #:	Machine Or	Operation:	Description :	
7.0	AN960JD416	Washer	·	114411141111411
do Co	mment: Qty.: 20 Washer batch:	0.0000 Each(s)/Unit Total : 20.0000 E	each(s)	
8.0	MS21042L4	Nut		111111111111111
Co Co	•	.0000 Each(s)/Unit Total : 6.0000 Ea	ach(s)	
	Nut batch:_ <i>M</i>	105938	Slala	sφ (/x)
9.0	QC5	INSPECT	TWORK TO CURRENT STEP	
	t- INDEST	MADRICTO OURRENT OTER	d c/a	
10.0	PACKAGING 1	WORK TO CURRENT STEP PACKAG	SING RESOURCE #1	
10.0	,			
Со		NG RESOURCE #1 id pack for shipping as per PPP D412-702	2-045B CHG001	
	Location:_	<u> </u>	1 - S 12	
11.0	PPP Rev		SPECTION/W/O RELEASE	
Co	mment: FINAL INS	SPECTION/W/O RELEASE		1208/02/15
Job Completion			· (/	08.015
			Q C	
*1				
				'

Dart Aerospace Ltd

WORK ORDER (PROCEDURE CHANGE	CHANGES By		1	Approval	
PROCEDURE CHANGE	Ву		T	Annroval	
		Date	Qty	Chief Eng / Prod Mgr	Approva QC Inspecto
•					
		···			
PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	· · · · · · · · · · · · · · · · · · ·
	QA:	N/C Close	d:	_ Date: _	
WORK ORDER NON-CON	IFORMANCE (NC	R)			
		QA:		QA: N/C Closed:	PAR #: Fault Category: NCR: Yes No DQA: Date: QA: N/C Closed: Date:

NCR:			WORK ORDI	ER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE STEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
								:

NOTE: Date & initial all entries

7

Page 40 of 42

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
Х					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	Х			i	D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		Х			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			х		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				Х	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	11		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*	.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	SCREW SHOP COPY
4*	4*			4*	MS24693S273	
4*	4*			4*	AN960JD10LL	
4*	4*			4*	MS21042L3	NUT' ENGINEERING
1	1				D412-702-107B	HARNESS ASSEMBLYNCONTROLLED CO
1*	1*			,	D3573-3	HARNESS ASSEMBLYNCONTROLL ADAPTER SUBJECT TO AMENDMENT ADAPTER S
1*	1*				D3579-046	I SHOULDER HARNESS WITHOUT TO
1*	1*				K6.2	CLIP WORK WORK
4*	4*				MS24693S272	SCREW 30 3 1 9 1
4*	4*				AN960JD10LL	WASHER NO.
4*	4*				MS21042L3	NUT
1	1			**	D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: **E**

Date: 07.06.27

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2	QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
1"	2		2		· · · ·	D412-702-111B	HARNESS ASSEMBLY
1						D3570-1	BRACKET
4"							SHOULDER HARNESS
4"				-			
4*							The second secon
2							
1°						D440 700 442B	HADNESS ASSEMBLY
1*							
4*							
4* 4* AN960JD10L WASHER 4* 4* MS2104ZL3 NUT 1 1 D412-702-115B HARNESS ASSEMBLY 1* 1* D3573-5 ADAPTER 1* 1* D3579-046 SHOULDER HARNESS 1* 1* K6.2 CLIP 4* 4* MS24993S272 SCREW 4* 4* MS24993S272 SCREW 4* 4* MS2104ZL3 NUT 1 1 D412-702-117B HARNESS ASSEMBLY 4* 4* MS2104ZL3 NUT 1* 1* D3579-045 SHOULDER HARNESS 1* 1* D3579-045 SHOULDER HARNESS 1* 1* K6.2 CLIP 4* 4* MS24693S272 SCREW 4* 4* MS24693S272 SCREW 4* 4* MS24693S272 SCREW 4* 4* MS24693S274 BRACKET 2 <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td>							
4*					ļ		
1							
1*	4*		4"		<u> </u>	WS21042L3	NOT
1	1			1		D412-702-115B	HARNESS ASSEMBLY
1*	1*			1*		D3573-5	
4*	1*			1*		D3579-046	SHOULDER HARNESS
4* 4* AN960JD10LL WASHER 4* 4* MS21042L3 NUT 1 1 D412-702-117B HARNESS ASSEMBLY 1* 1* D3573-5 SHOULDER HARNESS 1* 1* D3579-045 SHOULDER HARNESS 1* 1* K6.2 CLIP 4* 4* MS246935272 SCREW 4* 4* AN960JD10LL WASHER 4* 4* MS21042L3 NUT 2 2 D3542-1 BRACKET 4* 4* MS21042L3 NUT 2 2 D3571-3 GUIDE 2 2 D3571-3 GUIDE 2 2 D3571-3 GUIDE 3 4 1 D3571-3 GUIDE ASSEMBLY 2 2 D3610-041 BRACKET RELURNITO 2 2 D3610-041 BRACKET ENGINEERING 2 2 D3618-1 CAP	1*			1*		K6.2	CLIP
4* 4* MS21042L3 NUT 1 1 D412-702-117B HARNESS ASSEMBLY 1* 1* D3573-5 ADAPTER 1* 1* D3579-045 SHOULDER HARNESS 1* 1* K6.2 CLIP 4* 4* MS24693S272 SCREW 4* 4* AN960JD10LL WASHER 4* 4* MS21042L3 NUT 2 2 D3542-1 BRACKET 7 3 4 1 D3571-3 GUIDE 2 2 D3572-041 GUIDE ASSEMBLY SHOP COPY 2 2 D3578-041 DOUBLER RETURN TO 2 2 D3610-041 BRACKET ENGINEERING 2 2 D3618-1 CAP UNCONTROLLED COPY 2 2 D3618-1 CAP UNCONTROLLED COPY 4 4 AN4-10A BOLT SUBJECT TO AMENOMENT 2 2 AN4-16A </td <td>4*</td> <td></td> <td></td> <td>4*</td> <td></td> <td>MS24693S272</td> <td>SCREW</td>	4*			4*		MS24693S272	SCREW
1	4*			4*		AN960JD10LL	WASHER
1*	4*			4*		MS21042L3	NUT
1*	1			1		D412-702-117B	HARNESS ASSEMBLY
1* 1* D3579-045 SHOULDER HARNESS 1* 1* K6.2 CLIP 4* 4* MS24693S272 SCREW 4* 4* AN960JD10LL WASHER 4* MS21042L3 NUT 2 2 D3572-041 BRACKET 7 3 4 1 D3571-1 GUIDE 2 2 D3572-041 GUIDE ASSEMBLY SHOP COPY 12 6 6 2 D3578-041 DOUBLER RETURN TO 2 2 D3610-041 BRACKET ENGINEERING 2 2 D3618-1 CAP UNCONTROLLED COPY 2 2 D3618-1 CAP UNCONTROLLED COPY 4 4 AN4-10A BOLT SUBJECT TO AMENDADED 4 4 AN4-25A BOLT WITHOUT NOTICE 4 4 AN4-25A BOLT WITHOUT NOTICE 4 4 AN4-44A BOLT WITHOUT							
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4* 4* AN960JD10LL WASHER 4* 4* MS21042L3 NUT 2 2 D3542-1 BRACKET 7 3 4 1 D3571-1 GUIDE 2 2 D3571-3 GUIDE SHOP COPY 12 6 6 2 D3578-041 GUIDE ASSEMBLY SHOP COPY 12 6 6 2 D3578-041 DOUBLER RETURN TO 2 2 D3610-041 BRACKET ENGINEERING 2 2 D3618-1 CAP UNCONTROLLED COPY 2 2 AN4-10A BOLT WICONTROLLED COPY 4 4 AN4-16A BOLT SUBJECT TO AMENUMENT 2 2 AN4-16A BOLT WITHOUT NOTICE 4 4 AN4-25A BOLT WITHOUT NOTICE 2 2 AN4-44A BOLT WITHOUT NOTICE 3 3 3 1 MS24694556							
4* 4* MS21042L3 NUT 2 2 D3542-1 BRACKET 7 3 4 1 D3571-3 GUIDE 2 2 D3572-041 GUIDE ASSEMBLY STOP COPY 12 6 6 2 D3578-041 DOUBLER RETURN TO 2 2 D3610-041 BRACKET ENGINEERING 2 2 D3618-1 CAP UNCONTROLLED COPY 2 2 D3618-1 CAP UNCONTROLLED COPY 4 4 AN4-10A BOLT NO. 4 4 AN4-6A BOLT NO. 4 4 AN4-25A BOLT NO. 2 2 AN4-44A BOLT NO. 2 2 MS24693S274 SCREW NO. 3 3 1 MS24694S56 SCREW 10 2 8 MS24694S60 SCREW 10 2 AN960JD416<							
2 2 D3542-1 BRACKET 7 3 4 1 D3571-1 GUIDE 2 2 D3572-041 GUIDE 12 6 6 6 2 D3578-041 DOUBLER RETURN TO 12 10 D3610-041 BRACKET 13 D3618-1 CAP 14 4 DAM-10A BOLT UNCONTROLLED COPY 2 AN4-16A BOLT SUBJECT TO AMENDMENT 2 AN4-25A BOLT 2 AN4-44A BOLT 2 D3 MS24694S56 SCREW 1 D3 MS24694S56 SCREW 1 D3578-041 DOUBLER RETURN TO 2 D3578-041 DOUBLER RETURN TO 2 D3618-1 CAP 2 D3618-1 CAP 2 D3618-1 CAP 3 D3618-1 CAP 4 D3618-1 CAP 5 D3618-1 CAP 6 D361							
7 3 4 1 D3571-1 GUIDE 2 2 2 D3578-041 GUIDE STIOR COPY 2 D3572-041 GUIDE ASSEMBLY STIOR COPY 12 6 6 2 D3578-041 DOUBLER RETURN TO 12 1 D3610-041 BRACKET ENGINEERS COPY 2 2 D3618-1 CAP UNCONTROLLED COPY 4 4 4 BOLT SUBJECT TO AMENDMENT 2 2 2 AN4-16A BOLT SUBJECT TO AMENDMENT 4 AN4-25A BOLT SUBJECT TO AMENDMENT 4 AN4-44A BOLT SUBJECT TO AMENDMENT 2 2 2 MAN4-44A BOLT SUBJECT TO AMENDMENT 2 2 2 MAN4-44A BOLT SUBJECT TO AMENDMENT 3 3 3 S SCREW NO. SCREW 10 2 8 MS24694S56 SCREW 10 2 8 MS24694S58 SCREW 11 1 MS24694S60 SCREW 12 6 6 20 AN960JD416 WASHER 13 AN960JD416L WASHER							PDACKET
D3571-3 GUIDE D3572-041 GUIDE ASSEMBLY SHOP COPY					4		
12 6 6 2 D3578-041 DOUBLER RETURN TO D3610-041 BRACKET ENGINEERING				4	1		
12 6 6 2 D3578-041 DOUBLER RETURN TO D3610-041 BRACKET ENGINEERING		2					GOIDE COLVE COLVE
D3610-041 BRACKET ENGINEERS COPY			2				
D3618-1 CAP				6			DOUBLER RIGHT
2 AN4-16A BOLT SUBSTITUTION NOTICE 4 AN4-25A BOLT WITHOUT NOTICE 2 2 AN4-44A BOLT 2 2 MS24693S274 SCREW NO. 3 3 3 1 MS24694S56 SCREW 10 2 8 MS24694S58 SCREW 1 1 1 1 MS24694S60 SCREW 26 6 20 AN960JD416 WASHER 4 4 AN960JD416L WASHER 12 6 6 6 MS21042L4 NUT				-			BRACKET ENOUTED COPT
2 AN4-16A BOLT SUBSTITUTION NOTICE 4 AN4-25A BOLT WITHOUT NOTICE 2 2 AN4-44A BOLT 2 2 MS24693S274 SCREW NO. 3 3 3 1 MS24694S56 SCREW 10 2 8 MS24694S58 SCREW 1 1 1 1 MS24694S60 SCREW 26 6 20 AN960JD416 WASHER 4 4 AN960JD416L WASHER 12 6 6 6 MS21042L4 NUT							POLT UNCONTROLLENT
4		4				*****	
3 3 1 MS24694536 SCREW 10 2 8 MS24694S58 SCREW 1 1 1 MS24694S60 SCREW 26 6 20 AN960JD416 WASHER 4 4 AN960JD416L WASHER 12 6 6 MS21042L4 NUT							POLT WITHOUT ORDER
3 3 1 MS24694536 SCREW 10 2 8 MS24694S58 SCREW 1 1 1 MS24694S60 SCREW 26 6 20 AN960JD416 WASHER 4 4 AN960JD416L WASHER 12 6 6 MS21042L4 NUT		2	4		<u> </u>		BOLT WORK OF THE
3 3 1 MS24694536 SCREW 10 2 8 MS24694S58 SCREW 1 1 1 MS24694S60 SCREW 26 6 20 AN960JD416 WASHER 4 4 AN960JD416L WASHER 12 6 6 MS21042L4 NUT					-		SCREW NO 2
10 2 8 MS24694S58 SCREW 1 1 1 MS24694S60 SCREW 26 6 20 AN960JD416 WASHER 4 4 AN960JD416L WASHER 12 6 6 MS21042L4 NUT					1		SCREW
1 1 1 MS24694S60 SCREW 26 6 20 AN960JD416 WASHER 4 4 AN960JD416L WASHER 12 6 6 MS21042L4 NUT				- <u>8</u>	<u> </u>		
26 6 20 AN960JD416 WASHER 4 4 AN960JD416L WASHER 12 6 6 MS21042L4 NUT				- 	1		
4 4 AN960JD416L WASHER 12 6 6 MS21042L4 NUT			20		<u>'</u>		
12 6 6 MS21042L4 NUT			20				
			6				
	24	12		12	4	CR3212-4-4	RIVET

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Revision: **E**

Date: 07.06.27